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D3201-4
Job Sheet 187953



Part No: D3201-4

Job Qty: 2 ea

Part Name: Angle



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/21/18

Job Tracking No:

Due Date: 12/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev: A Removed from 9 Digit 06-01-25 JLM IPP Rev:B Now on Waterjet 06-08-14 JLM IPP
Rev :C Added scribing, NCR262 07.11.29 EC IPP Rev:D 10.10.29 remove scribe b# & p# DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	2 pcs		12/28/18	0.00	0.05	Waterjet - Flow		JL 12/28/18
120	QC	2 pcs		12/28/18	0.00	0.00	QC8		38
140	Brake NC	2 pcs		12/28/18	0.09	0.04	Brake NC 1		DAS 38
150	QC	2 pcs		12/28/18	0.00	0.00	QC5		38
160	HandFinish	2 pcs		12/28/18	0.00	0.06	HandFinish1		D.R 12/28/18
170	QC	2 pcs		12/28/18	0.00	0.00	QC7-2		38
180	Packaging	2 pcs		12/28/18	0.00	0.00	Packaging3-1	51023	DAS 38
190	QC21-SA	2 Ea		12/28/18	0.00	0.00	QC21		21 JAN 24 2019

Part Op 100 - 1-Cut as per Dwg D3201 (CHECK GRAIN DIRECTION BEFORE CUTTING)
Descriptions: 140 - 1-Bend as per Dwg D3201

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.050	2024-T3 .050 Sheet	.0900 sf (.045 ea)	100-Waterjet - Flow - 1	U137626

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.050	0	16	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	3.760inches $\pm$ 0.030	3.790 3.730	3.757	
2	Doubler	3.460inches $\pm$ 0.030	3.490 3.430	3.461	
3	Doubler	1.680inches $\pm$ 0.030	1.710 1.650	1.676	
4	Doubler	0.050inches $\pm$ 0.010	0.060 0.040	0.047	

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No. _____

Route update only

Job: _____ Part No. _____		DISPOSITION	
Date : _____		Sequence #: _____	
Description Work Order Deviation			
Container No: S143999 Part: D3201 - 4 Job No: 187953 Serial No/Batch: S143999 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 01/10/19			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	
Other/Details:		☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread	